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**Kroll et al.**

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(54) **ADDITIVE LAYER MANUFACTURING  
METHOD FOR PRODUCING A  
THREE-DIMENSIONAL OBJECT**

(58) **Field of Classification Search**

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**ABSTRACT**

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(52) **U.S. Cl.**  
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An additive layer manufacturing method is disclosed for  
producing a three-dimensional object and to a corresponding  
object. Layers of a powder material are applied to a carrier  
and irradiated, before the following layer is applied, with a  
laser beam or particle beam selectively only in the areas of  
the layer which correspond to the three-dimensional object  
to be produced. Irradiation occurs such that the powder  
material in the corresponding areas is locally melted or  
sintered. A first portion is constructed before a second  
portion or the first portion is provided as a separate com-  
ponent, on which a support structure and second portion are  
constructed. The support structure is constructed in the form

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